

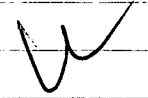
# Work Order ID 107049



September-16-13 12:56:39 PM

**\*107049\***

Page 1

Item ID: D4635-044 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Ceiling Panel Assembly, RH  
 Start Date: 9/16/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 9/18/13 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan:  Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
<b>Draw Nbr</b>	<b>Revision Nbr</b>								
D4635	C								
100		0.00							
<b>*100*</b>									
HandThermo	Memo	0.00							
Hand Finishing Thermoforming	Pick Kit								9/09/16
110		0.00							
<b>*110*</b>									
Small Fab	Memo	0.00							
Small Fab	1- Assemble as per Dwg D4635-044								13/09/18
	2-Install speaker								
	3- Install Air valve								
	4-Install Wiring Harness								
	5-Install wiring harness								

# Work Order ID 107049



**\*107049\***

Page 2

September-16-13 12:56:39 PM

Item ID: D4635-044 Accept **\*N900040100\*** Setup Start **\*NS1\***  
 Revision ID: Stop **\*NS2\***  
 Item Name: Aft Ceiling Panel Assembly, RH  
 Start Date: 9/16/13 Start Qty: 1.00 **\*1\*** Cust Item ID:  
 Required Date: 9/18/13 Req'd Qty: 1.00 **\*1\*** Customer:  
 Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
 QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC6- Inspect dimensions to drawing  Memo	0.00 DAS 16 9-89 13/09/19							
130 <b>*130*</b> Packaging Packaging	Identify as per dwg & Stock Location: _____  Memo PPP 106993	0.00 0.00				1	8	13-9-19	
140 <b>*140*</b> QC Quality Control	QC21- Final Inspection - Work Order Release  Memo	0.00 0.00						13/9/20	 MF 13-9-20

# Picklist Print

September-16-13 12:56:38 PM

Page 1

Work Order ID: 107049

Parent Item: D4635-044

Parent Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 9/16/13

Required Date: 9/18/13

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev. A 12/08/09 New Issue DL  
DL IPP Rev B 12/11/08 Doc Release  
IPP Rev C Dwg. Update 13/07/09 DL verf:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D4635-144 Aft Ceiling Replacement Panel Assembly, RH ✓		Manufactured	No	104788		100	Each	0.0000	1	1			DA 07 89 13/09/16
D4646-1 Plenum Cap Assembly ✓		Manufactured	No			100	Each	108.0000	1	1			DA 07 89 13/09/16
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST117		24							
				92968		12							
				95779		12							
				ST127		84							
				103832		84			1				
D4652-1 Air Valve, 1.16 Id Disk Type ✓		Manufactured	No			100	Each	216.0000	1	1			DA 07 89 13/09/16
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st113		192							
				103831		192							
				ST117		12							
				93032		12			1				
				ST118		12							
				95907		12							
D4652-3 Mounting Nut N/A		Manufactured	No			100	Each	0.0000	1	1			
D4655-1 Speaker ✓		Manufactured	No			100	Each	62.0000	1	1			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				st113		14							
				93061		14			1				
				ST478		48							
				103939		48							

# Picklist Print

September-16-13 12:56:38 PM

Page 2

Work Order ID: 107049

Parent Item: D4635-044

Parent Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 9/16/13

Required Date: 9/18/13

Start Qty: 1.00

Required Qty: 1.00

D4708-9  
Lanyard ✓

Manufactured No

100 Each 18.0000

1 1

Location

Loc Qty

Loc Code

ST118

18

92290

6

93919

12

①

13/09/16

D4728-046  
RH Cabin Speaker #3 ✓

Manufactured No

100 Each 2.0000

1 1

Location

Loc Qty

Loc Code

ST120

2

93453

2

①

13/09/16

D4743-1  
Speaker Grill ✓

Manufactured No

100 Each 2.0000

1 1

Location

Loc Qty

Loc Code

prelim

2

93142

2

①

13/09/18

MS21044-N08 ✓  
Nut

Purchased No

100 Each 160.0000

4 4

Location

Loc Qty

Loc Code

ST316

160

123741

160

④

13/09/14

MS21919-WDG8 ✓  
Clamp

Purchased No

100 Each 22.0000

3 3

Location

Loc Qty

Loc Code

ST322

22

123900

2

125445

20

③

13/09/16

MS24693-BB51 ✓  
Screw

Purchased No

100 Each 76.0000

4 4

Location

Loc Qty

Loc Code

ST299

76

124704

76

4

13/09/16

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Shop Packet Print

Page 2

# Picklist Print

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Page 3

Work Order ID: 107049

Parent Item: D4635-044

Parent Item Name: Aft Ceiling Panel Assembly, RH

Start Date: 9/16/13

Required Date: 9/18/13

Start Qty: 1.00

Required Qty: 1.00

NAS1149DN832J ✓

Purchased

No

100

Each

4,675.0000

4

4

Washer

Location

Loc Qty

Loc Code

ST293

675

123603

5

124555

398

M126221

272

ST510a

4000

M126319

4000

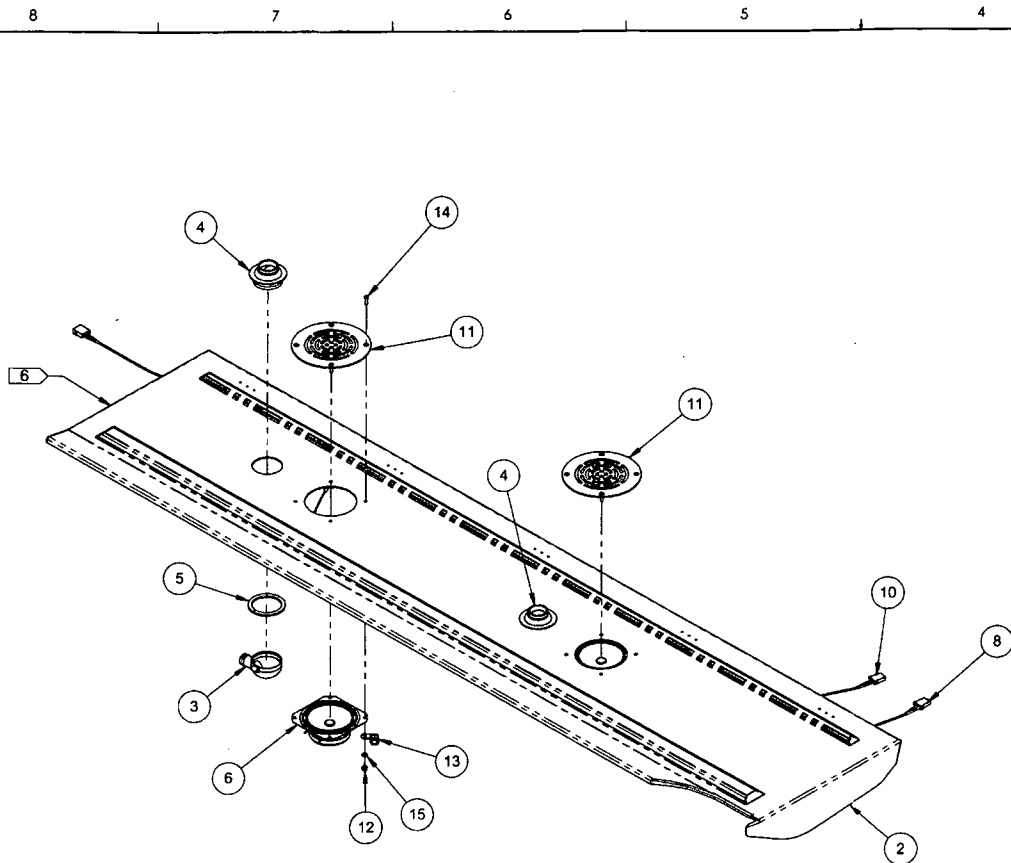
68-21  
20  
13/09/16

(4)

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Shop Packet Print

Page 3



**D4635-041 LH. FWD CEILING PANEL ASSY**

**NOTES:**

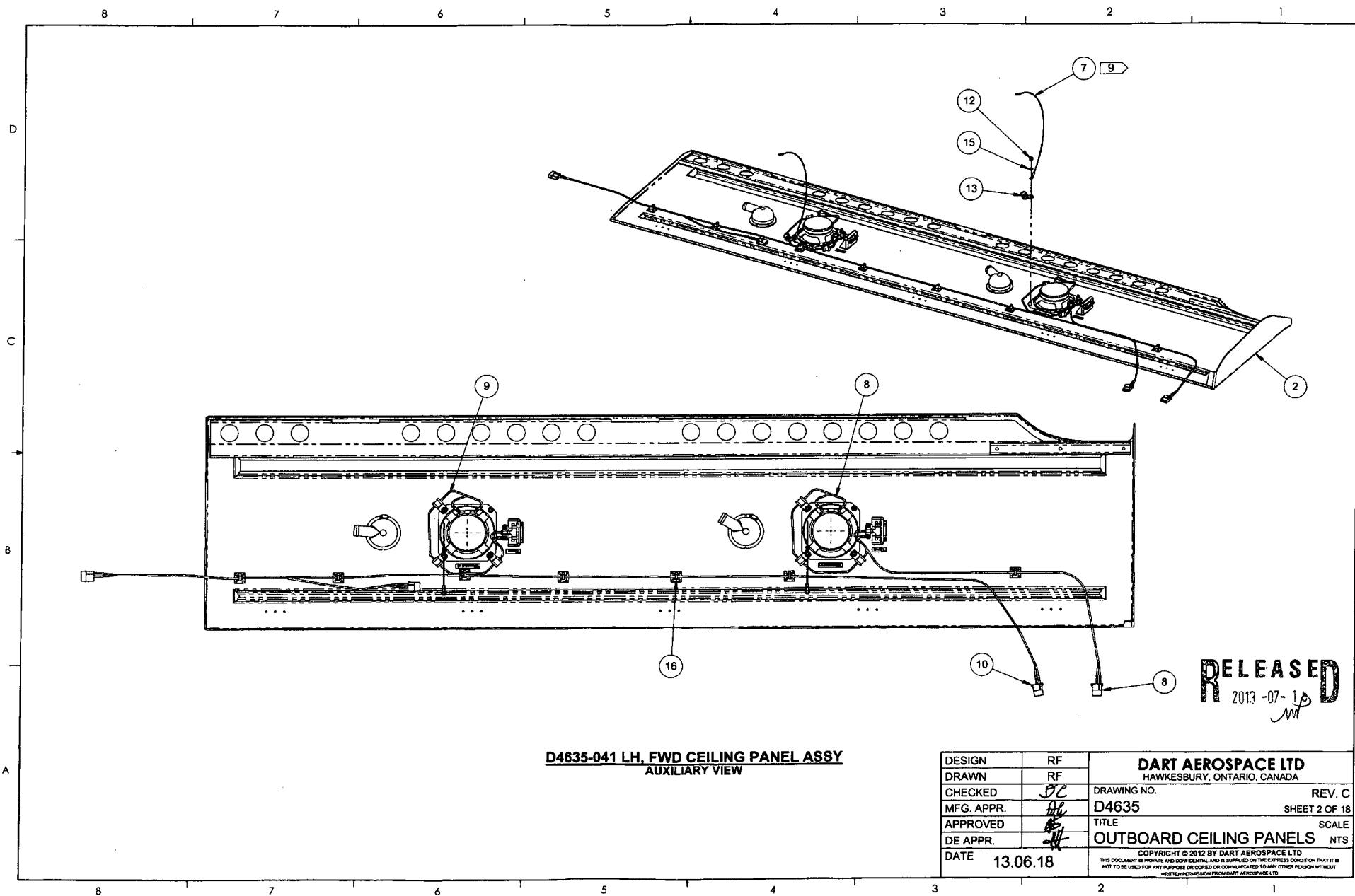
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.8 lbs
- 8) INSTALL D4728-041/-043/-059 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

ITEM NO.	QTY. -041	PART NUMBER	DESCRIPTION
1	X	D4635-041	LH, FWD CEILING PANEL ASSY
2	1	D4635-141	LH, FWD CEILING REPLACEMENT PANEL ASSY
3	2	D4646-1	PLENUM CAP ASSEMBLY
4	2	D4652-1	AIR VALVE
5	2	D4652-3	MOUNTING NUT
6	2	D4655-1	SPEAKER
7	2	D4708-9	LANYARD
8	1	D4728-041	LH SPEAKER #1 HARNESS ASSEMBLY
9	1	D4728-043	LH SPEAKER #2 HARNESS ASSEMBLY
10	1	D4728-059	CABIN LIGHT HARNESS
11	2	D4743-1	SPEAKER GRILL
12	8	MS21044-N08	NUT
13	6	MS21919WDG8	CLAMP
14	8	MS24693-BB51	SCREW
15	8	NAS1149DN832J	WASHER
16	7	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

2/0  
107049

**RELEASED**  
2013-07-15

C	REVISE NOTE 8) (ZN A8-9, A8-10, A8-11 & A8-12); 32 WAS 34 (ZN C5-15, B5-16); CORRECT TYPO #1 WAS #3 (ZN D4-3); CHANGE TOLERANCE (ZN C3-13, B2-14, B5-17, B7-17, D2-17, D4-17, A3-18)	RF	13.06.18
B	ADDED D4635-141/-142/-143/-144 (ZN B4-9, B4-10, B4-11, B4-12); REVISE D4635-041/-042/-043/-044 PART LIST & GENERAL NOTES; ADDED D4732-41 (ZN B5-8); CHANGE TO D4743-1 SPEAKER GRILL AND MS24693-BB51 SCREWS (SHT 1, 3, 5, 7); ADD VIEWS R-R (ZN A7-17) AND S-S (ZN A5-17); UPDATE DETAIL D (ZN C7-18)	RF	12.11.30
A	NEW ISSUE	RF	12.07.25
REV.	DESCRIPTION	BY	DATE
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. C
MFG. APPR.	RF	D4635	SHEET 1 OF 18
APPROVED	RF	TITLE	SCALE
DE APPR.	RF	OUTBOARD CEILING PANELS	NTS
DATE	13.06.18	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD  THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

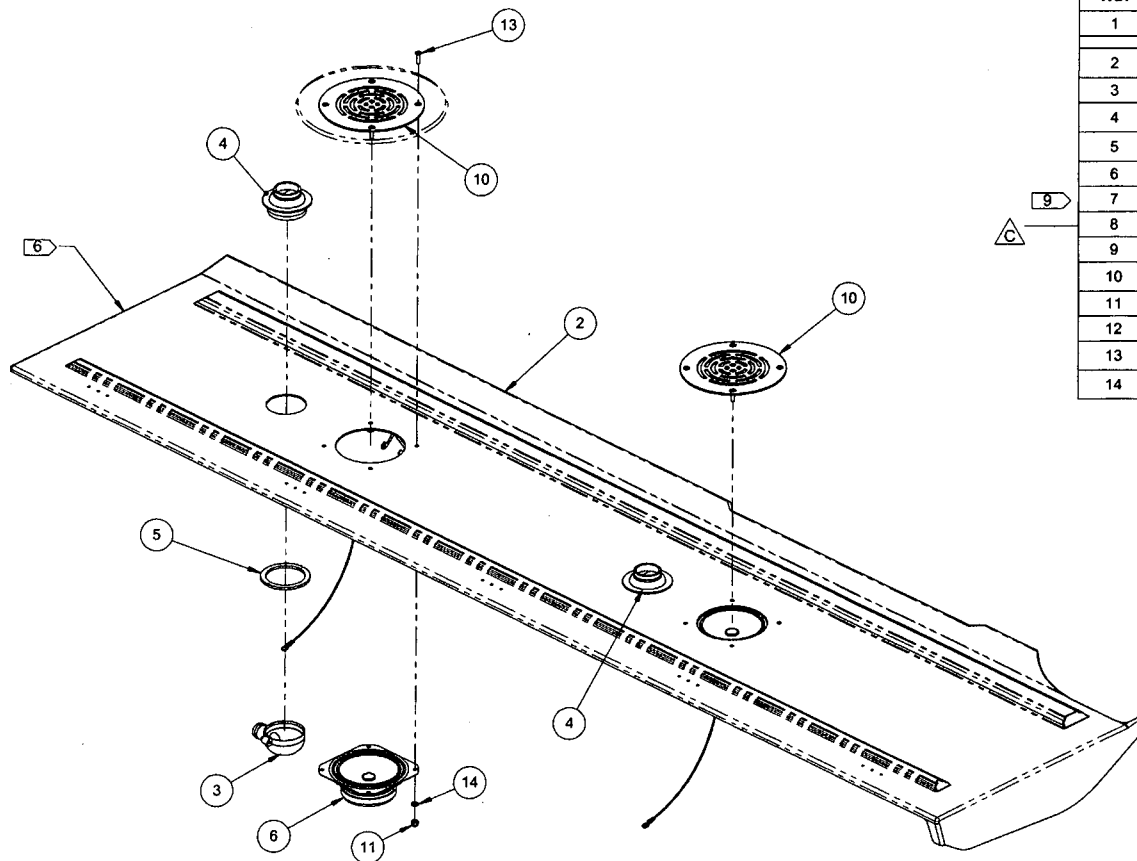


**D4635-041 LH, FWD CEILING PANEL ASSY**  
**AUXILIARY VIEW**

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 2013-07-18  
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CHECKED	<i>DC</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>AL</i>	<b>D4635</b>	SHEET 2 OF 18
APPROVED	<i>AL</i>	TITLE	SCALE
DE APPR.	<i>AL</i>	<b>OUTBOARD CEILING PANELS</b>	NTS
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8 7 6 5 4 3 2 1



ITEM NO.	QTY. -042	PART NUMBER	DESCRIPTION
1	X	D4635-042	RH, FWD CEILING PANEL ASSY
2	1	D4635-142	RH, FWD CEILING REPLACEMENT PANEL ASSY
3	2	D4646-1	PLENUM CAP ASSEMBLY
4	2	D4652-1	AIR VALVE
5	2	D4652-3	MOUNTING NUT
6	2	D4655-1	SPEAKER
7	2	D4708-9	LANYARD
8	1	D4728-042	RH SPEAKER #1 HARNESS ASSEMBLY
9	1	D4728-044	RH SPEAKER #2 HARNESS ASSEMBLY
10	2	D4743-1	SPEAKER GRILL
11	8	MS21044-N08	NUT
12	6	MS21919WDG8	CLAMP
13	8	MS24693-BB51	SCREW
14	8	NAS1149DN832J	WASHER

D4635-042 RH, FWD CEILING PANEL ASSY

## NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 7.8 lbs
- 8) INSTALL D4728-042/-044 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

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2013-07-15

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DRAWN	RF		
CHECKED	JTC	DRAWING NO.	REV. C
MFG. APPR.	dy	D4635	SHEET 3 OF 18
APPROVED	dy	TITLE	SCALE
DE APPR.	dy	OUTBOARD CEILING PANELS	NTS
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8 7 6 5 4 3 2 1

D

C

B

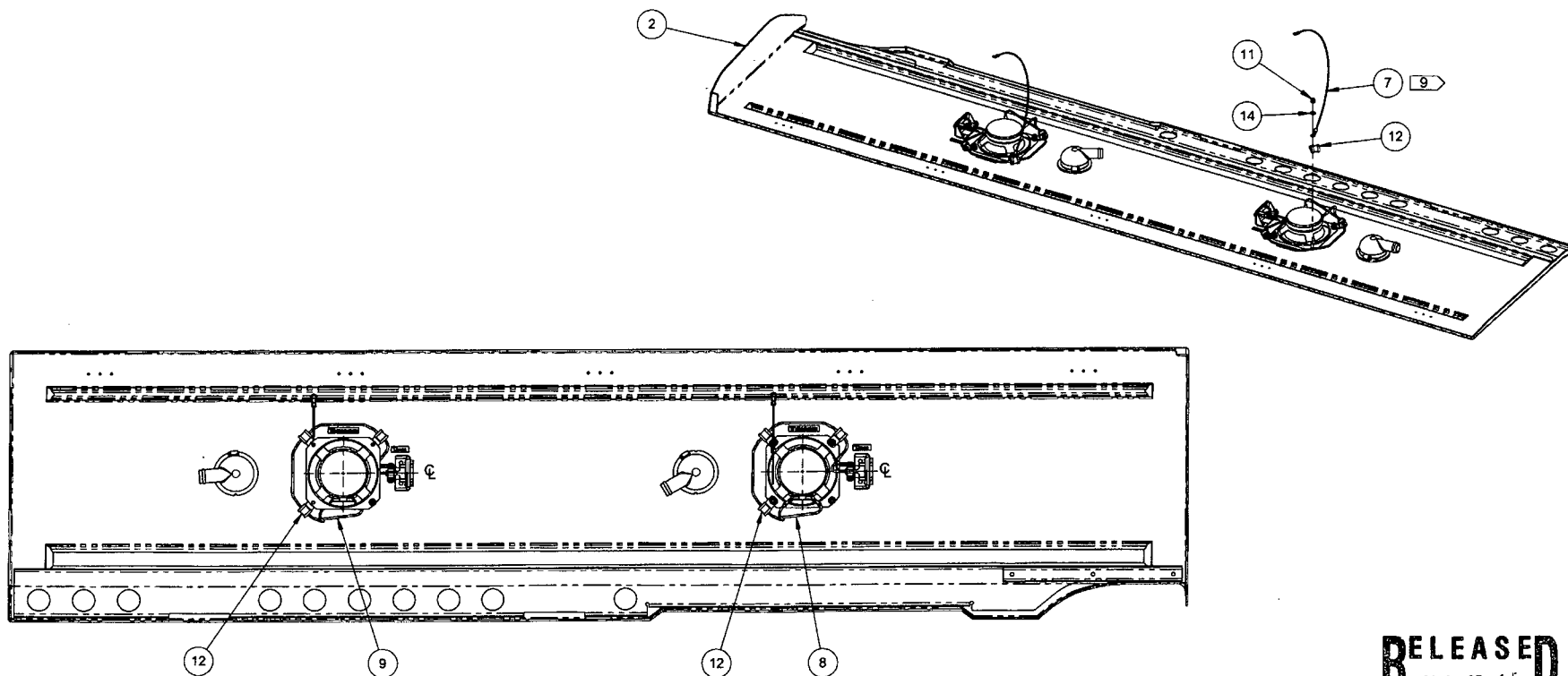
A

D

C

B

A

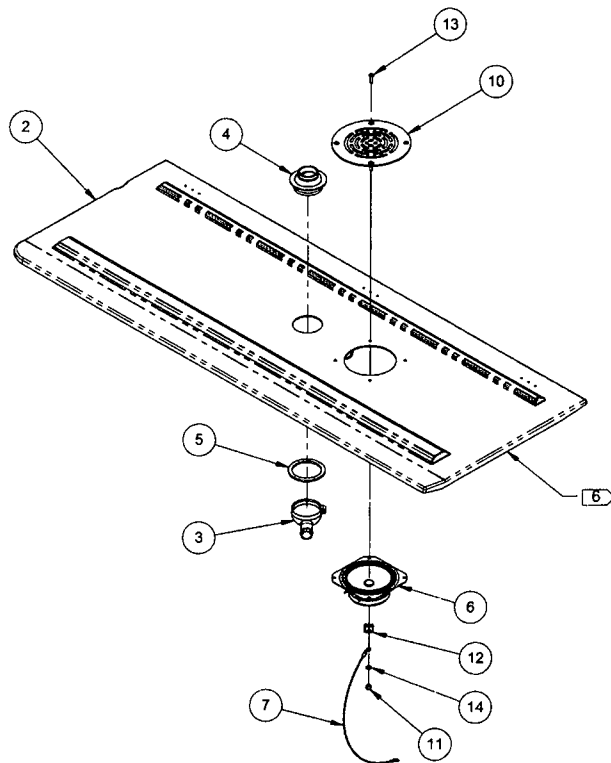


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2013-07-15  
*W*

**D4635-042 RH. FWD CEILING PANEL ASSY**  
AUXILIARY VIEW

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CHECKED	<i>BC</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>BC</i>	<b>D4635</b>	SHEET 4 OF 18
APPROVED	<i>BC</i>	TITLE	SCALE
DE APPR.	<i>BC</i>	<b>OUTBOARD CEILING PANELS</b>	NTS
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8 7 6 5 4 3 2 1



**D4635-043 LH, AFT CEILING PANEL ASSY**

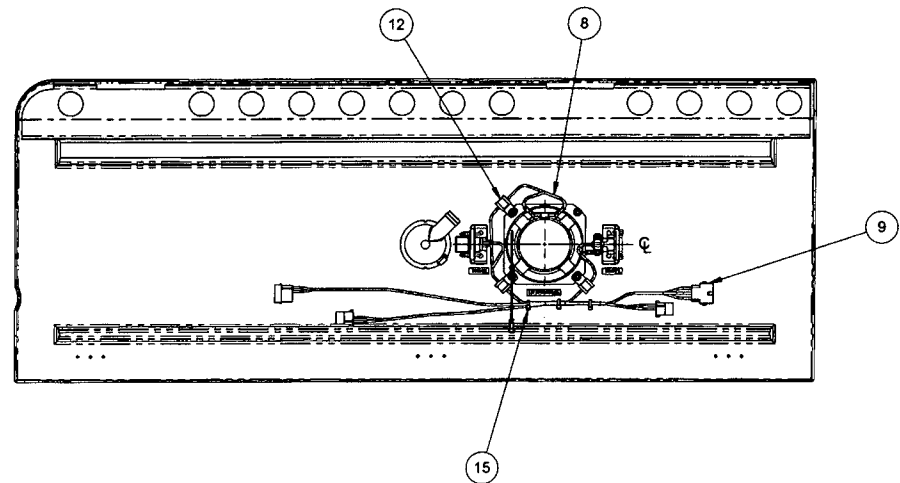
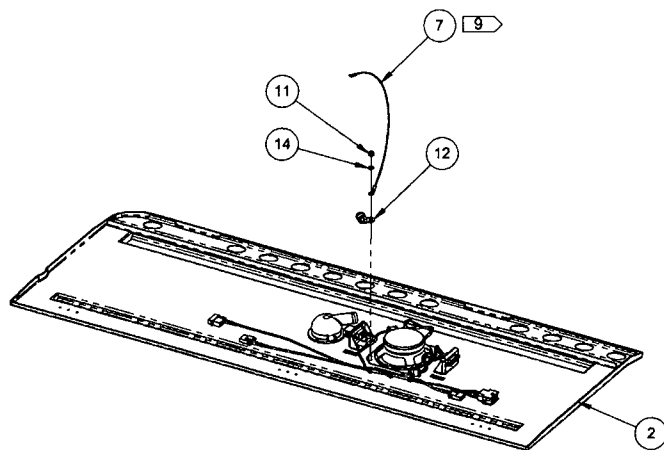
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 4.5 lbs
- 8) INSTALL D4728-045/-061 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

ITEM NO.	QTY. -043	PART NUMBER	DESCRIPTION
1	X	D4635-043	LH, AFT CEILING PANEL ASSY
2	1	D4635-143	LH, AFT CEILING REPLACEMENT PANEL ASSY
3	1	D4646-1	PLENUM CAP ASSEMBLY
4	1	D4652-1	AIR VALVE
5	1	D4652-3	MOUNTING NUT
6	1	D4655-1	SPEAKER
7	1	D4708-9	LANYARD
8	1	D4728-045	LH SPEAKER #3 HARNESS ASSEMBLY
9	1	D4728-061	CABIN LIGHTS CONTROL RELAY HARNESS ASSEMBLY
10	1	D4743-1	SPEAKER GRILL
11	4	MS21044-N08	NUT
12	3	MS21919WDG8	CLAMP
13	4	MS24693-BB51	SCREW
14	4	NAS1149DN832J	WASHER
15	3	PLT1.5M-M	TIE-WRAP (OR PLT1.5M-C)

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2013-07-15

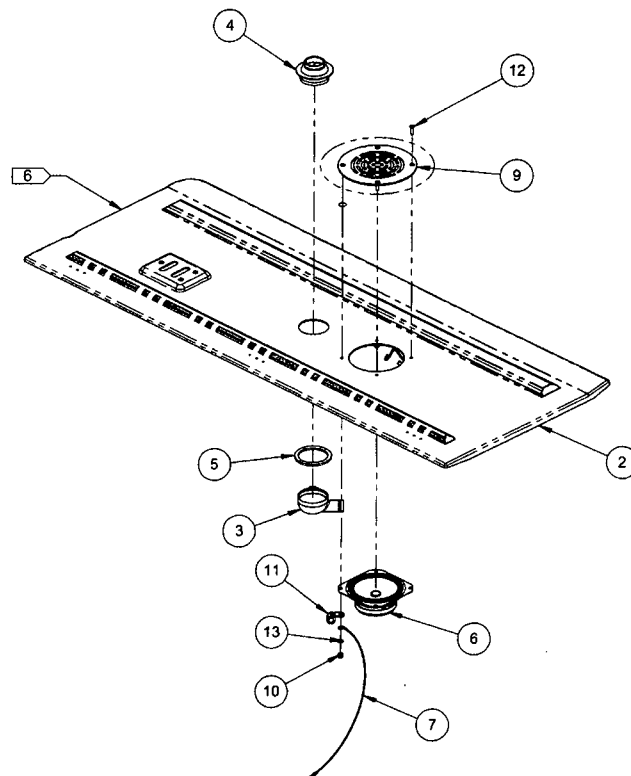
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DRAWN	RF		
CHECKED	PC	DRAWING NO.	REV. C
MFG. APPR.	PC	<b>D4635</b>	SHEET 5 OF 18
APPROVED	PC	TITLE	SCALE
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**D4635-043 LH, AFT CEILING PANEL ASSY**  
AUXILIARY VIEW

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2013-07-15  
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DRAWN	RF		
CHECKED	<i>DC</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>DC</i>	<b>D4635</b>	SHEET 6 OF 18
APPROVED	<i>DC</i>	TITLE	SCALE
DE APPR.	<i>DC</i>	<b>OUTBOARD CEILING PANELS</b>	NTS
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**D4635-044 RH, AFT CEILING PANEL ASSY**

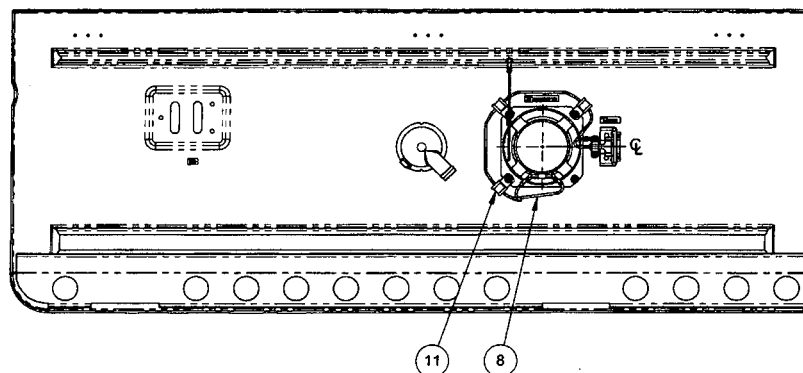
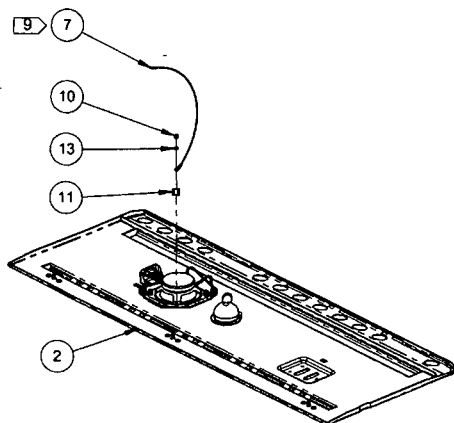
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 6.4, ON SMOOTH SIDE
- 7) WEIGHT: 4.5 lbs
- 8) INSTALL D4728-046 WIRE HARNESS PER QSI 048
- 9) ON D4708-9 LANYARD OPEN TO Ø0.196 BOTH ENDS

ITEM NO.	QTY. -044	PART NUMBER	DESCRIPTION
1	X	D4635-044	RH, AFT CEILING PANEL ASSY
2	1	D4635-144	RH, AFT CEILING REPLACEMENT PANEL ASSY
3	1	D4646-1	PLENUM CAP ASSEMBLY
4	1	D4652-1	AIR VALVE
5	1	D4652-3	MOUNTING NUT
6	1	D4655-1	SPEAKER
7	1	D4708-9	LANYARD
8	1	D4728-046	RH SPEAKER #3 HARNESS ASSEMBLY
9	1	D4743-1	SPEAKER GRILL
10	4	MS21044-N08	NUT
11	3	MS21919WDG8	CLAMP
12	4	MS24693-BB51	SCREW
13	4	NAS1149DN832J	WASHER

**RELEASED**  
2013-07-15

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	DC	D4635	SHEET 7 OF 18
APPROVED	DC	TITLE	SCALE
DE APPR.	DC	OUTBOARD CEILING PANELS	NTS
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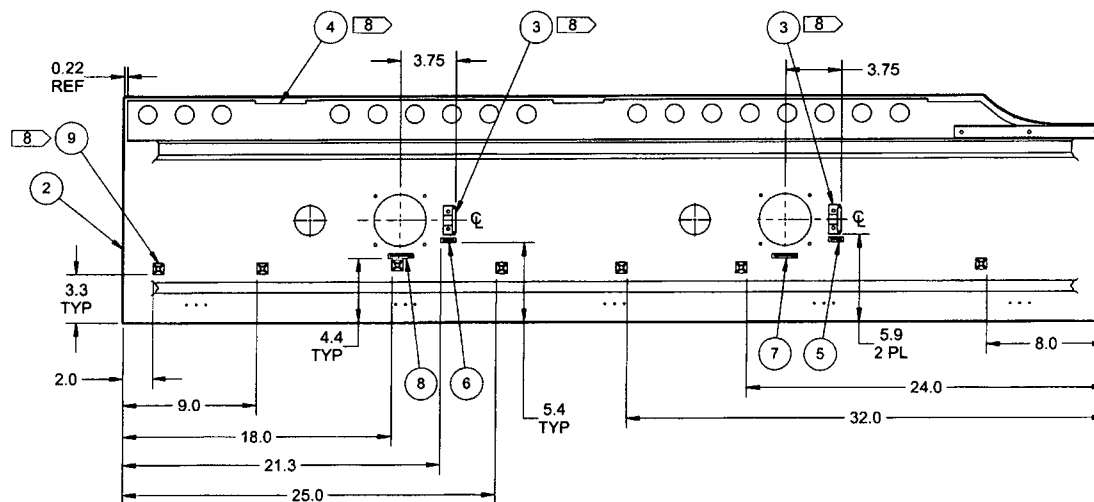


**D4635-044 RH, AFT CEILING PANEL ASSY**  
AUXILIARY VIEW

**RELEASED**  
2013-07-15

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DC	DRAWING NO.	REV. C
MFG. APPR.	HL	D4635	SHEET 8 OF 18
APPROVED	HL	TITLE	SCALE
DE APPR.	HL	OUTBOARD CEILING PANELS	NTS
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ITEM NO.	QTY. -141	PART NUMBER	DESCRIPTION
1	X	D4635-141	LH, FWD CEILING REPLACEMENT PANEL ASSY
2	1	D4635-1	LH, FWD CEILING PANEL
3	2	D4669-1	BRACKET
4	1	D4695-041	LH CHANNEL ASSEMBLY
5	1	D4732-5	LABEL
6	1	D4732-9	LABEL
7	1	D4732-29	LABEL
8	1	D4732-33	LABEL
9	7	MPNY-750S-9-C	MOUNTING PAD



**D4635-141 LH, FWD CEILING REPLACEMENT PANEL ASSY**

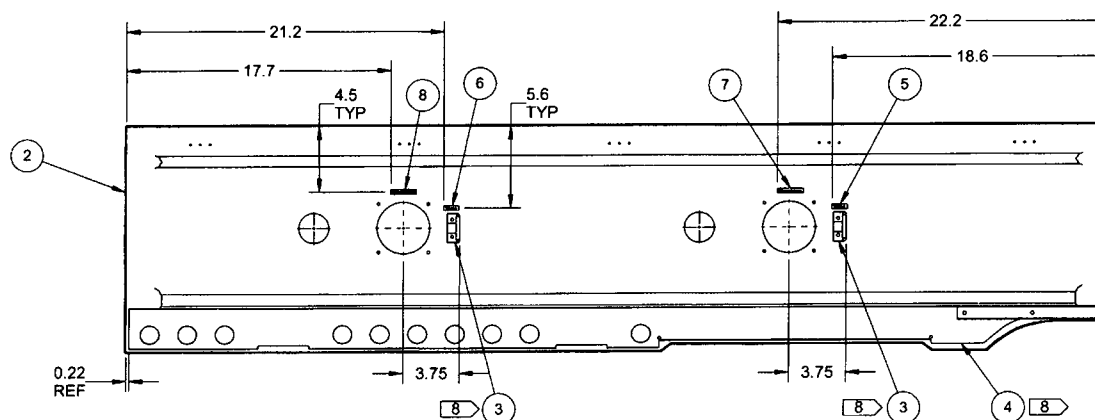
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.5 lbs
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4669-1, D4695-041 & MPNY-750S-9C. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) ALIGN THE LONGITUDINAL BEND IN D4695-041 CHANNEL WITH THE BEND ON D4635-1 PANEL & CENTER D4695-041 BETWEEN BOTH ENDS OF D4635-1

**RELEASED**  
2013-07-15

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	PC	D4635	SHEET 9 OF 18
MFG. APPR.	PC	TITLE	SCALE
APPROVED	PC	<b>OUTBOARD CEILING PANELS</b>	NTS
DE APPR.	PC	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	13.06.18		

ITEM NO.	QTY. -142	PART NUMBER	DESCRIPTION
1	X	D4635-142	RH, FWD CEILING REPLACEMENT PANEL ASSY
2	1	D4635-2	RH, FWD CEILING PANEL
3	2	D4669-1	BRACKET
4	1	D4695-042	RH CHANNEL ASSEMBLY
9	5	D4732-3	LABEL
9	6	D4732-7	LABEL
9	7	D4732-31	LABEL
9	8	D4732-35	LABEL



**D4635-142 RH, FWD CEILING REPLACEMENT PANEL ASSY**

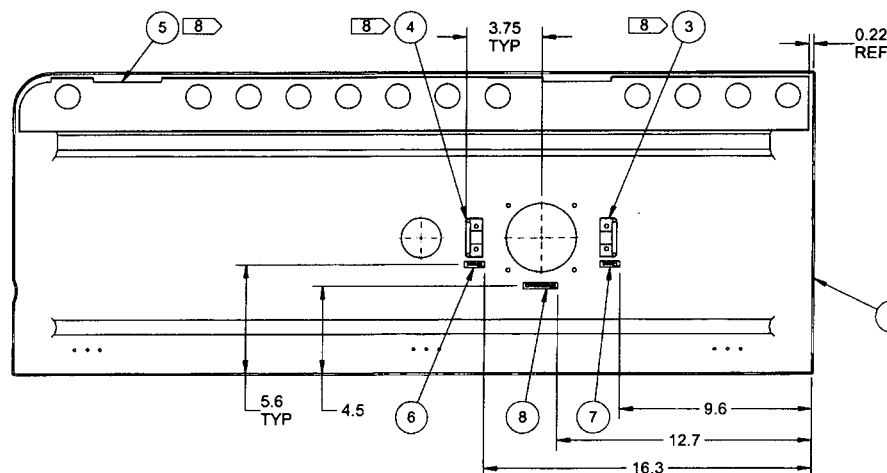
**RELEASED**  
2013-07-15

**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.5 lbs
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4669-1 & D4695-042. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) ALIGN THE LONGITUDINAL BEND IN D4695-042 CHANNEL WITH THE BEND ON D4635-2 PANEL & CENTER D4695-042 BETWEEN BOTH ENDS OF D4635-2

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF	DRAWING NO.	REV. C
CHECKED	PC	D4635	SHEET 10 OF 18
MFG. APPR.	AL	TITLE	SCALE
APPROVED	AL	OUTBOARD CEILING PANELS	NTS
DE APPR.	AL	COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	
DATE	13.06.18		

ITEM NO.	QTY. -143	PART NUMBER	DESCRIPTION
1	X	D4635-143	LH, AFT CEILING REPLACEMENT PANEL ASSY
2	1	D4635-3	LH, AFT CEILING PANEL
3	1	D4669-1	BRACKET
4	1	D4669-3	BRACKET
5	1	D4695-3	CHANNEL
6	1	D4732-1	LABEL
7	1	D4732-13	LABEL
8	1	D4732-37	LABEL



**D4635-143 LH, AFT CEILING REPLACEMENT PANEL ASSY**

**NOTES:**

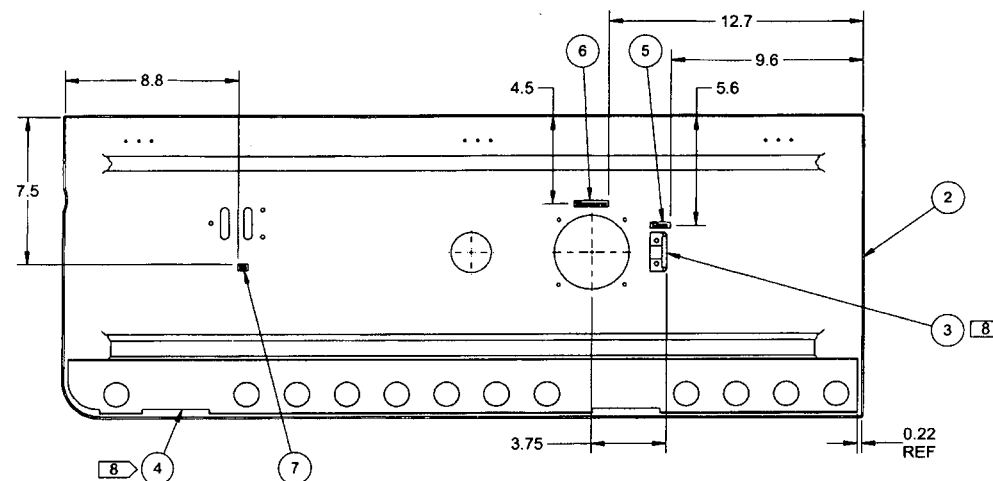
- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.5 lbs
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4669-1/-3, D4695-3. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) ALIGN THE LONGITUDINAL BEND IN D4695-3 CHANNEL WITH THE BEND ON D4635-3 PANEL & CENTER D4695-3 BETWEEN BOTH ENDS OF D4635-3

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	PL	DRAWING NO.	REV. C
MFG. APPR.	PL	D4635	SHEET 11 OF 18
APPROVED	PL	TITLE	SCALE
DE APPR.	PL	OUTBOARD CEILING PANELS	NTS
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2013-07-15



ITEM NO.	QTY. -144	PART NUMBER	DESCRIPTION
1	X	D4635-144	RH, AFT CEILING REPLACEMENT PANEL ASSY
2	1	D4635-4	RH, AFT CEILING PANEL
3	1	D4669-1	BRACKET
4	1	D4695-4	CHANNEL
5	1	D4732-11	LABEL
6	1	D4732-39	LABEL
7	1	D4732-41	LABEL



**D4635-144 RH, AFT CEILING REPLACEMENT PANEL ASSY**

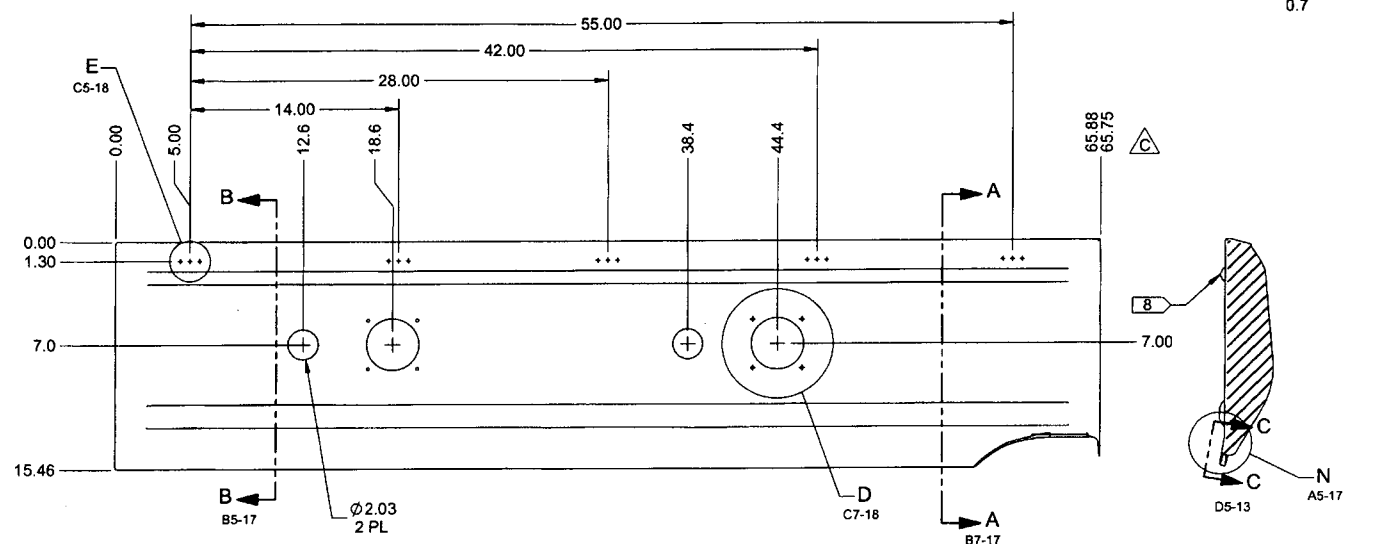
**NOTES:**

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.5 lbs
- 8) APPLY A BEAD (0.20 TO 0.30 WIDE) OF DEVCON PLASTIC WELDER II (0.25 INSIDE OF BOTH EDGES OF PART) TO BOND D4669-1, D4695-4. WAIT FOR 2 TO 4 HOURS FOR FUNCTIONAL CURE
- 9) LOCATE LABELS AS SHOWN, SEAL LABELS USING 3950 EDGE SEALER OVER LABEL TOP SURFACE
- 10) ALIGN THE LONGITUDINAL BEND IN D4695-4 CHANNEL WITH THE BEND ON D4635-4 PANEL & CENTER D4695-4 BETWEEN BOTH ENDS OF D4635-4

**RELEASED**  
2013 -07- 15  
*WP*

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>DC</i>	DRAWING NO.	REV. C
MFG. APPR.	<i>DC</i>	<b>D4635</b>	SHEET 12 OF 18
APPROVED	<i>DC</i>	TITLE	SCALE
DE APPR.	<i>DC</i>	<b>OUTBOARD CEILING PANELS</b>	NTS
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VIEW C-C B2-13



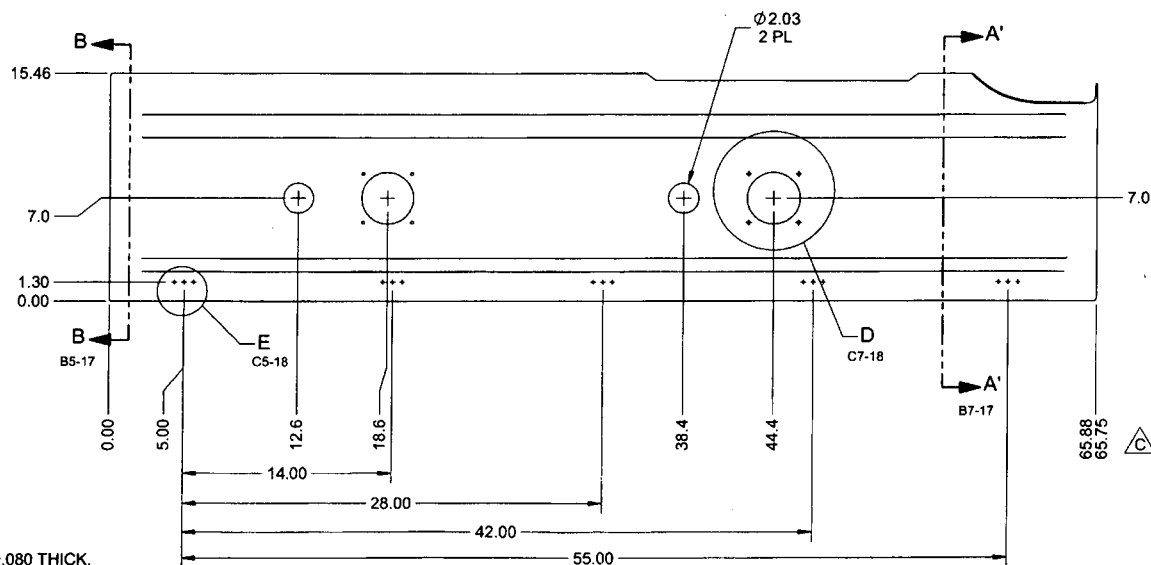
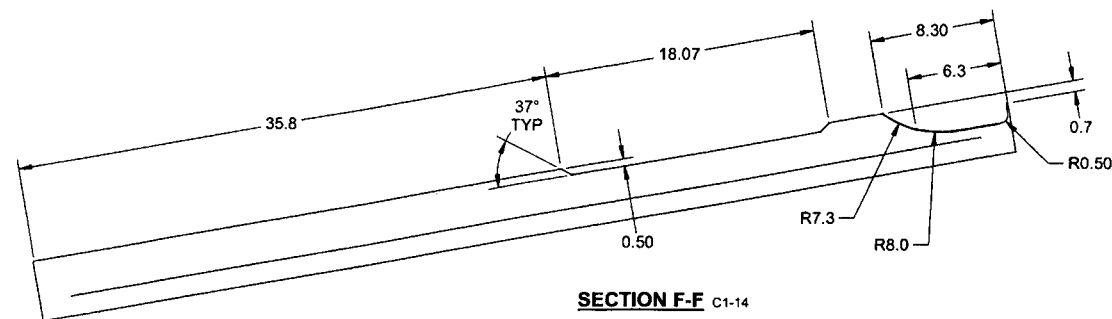
NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,  
P3-VELOUR MATTE, STEEL GRAY #52068  
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.29 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-1 PER TOOL DT9839
- 10) THERMOFORM D4635-1 PER QSI 022 USING DT9847 TOOL  
MIN. THICKNESS AFTER FORMING:  
SHADED AREA = 0.040  
RIDGES/EDGES = 0.060  
ELSEWHERE = 0.070

D4635-1 LH, FWD CEILING PANEL

RELEASED  
2013-07-15

DESIGN	RF	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4635	SHEET 13 OF 18
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	OUTBOARD CEILING PANELS	NTS
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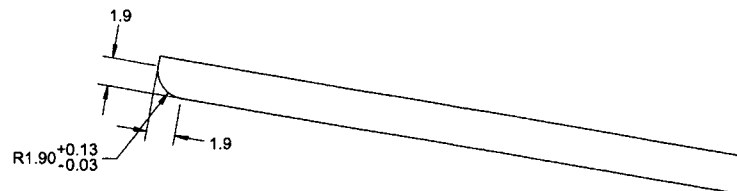
# NOTES:

- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,  
P3-VELOUR MATTE, STEEL GRAY #52068  
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 4.28 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-2 PER TOOL DT9840
- 10) THERMOFORM D4635-2 PER QSI 022 USING DT9847 TOOL  
MIN. THICKNESS AFTER FORMING:  
SHADED AREA = 0.040  
RIDGES/EDGES = 0.060  
ELSEWHERE = 0.070

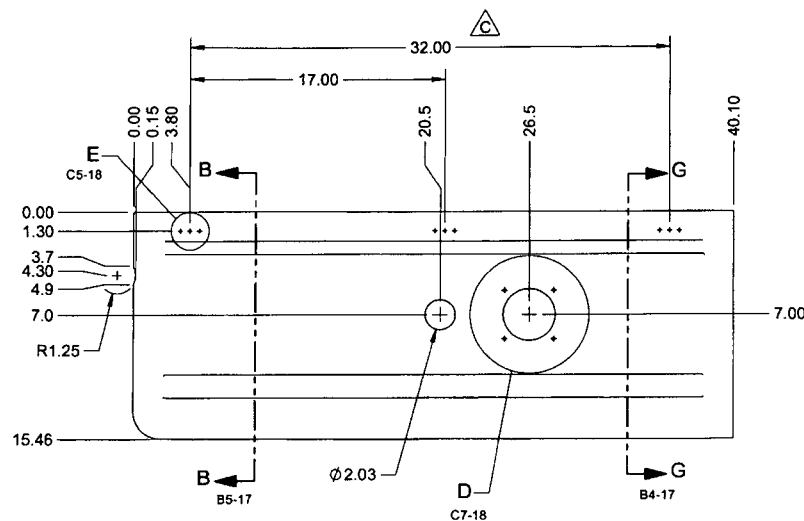
## **D4635-2 RH, FWD CEILING PANEL**

**RELEASED**  
2013-07-15

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DL	DRAWING NO.	REV. C
MFG. APPR.	DL	<b>D4635</b>	SHEET 14 OF 18
APPROVED	DL	TITLE	SCALE
DE APPR.	DL	<b>OUTBOARD CEILING PANELS</b>	NTS
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**SECTION H-H B2-15**



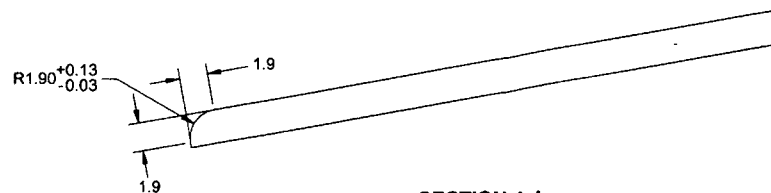
**D4635-3 LH, AFT CEILING PANEL**

**NOTES:**

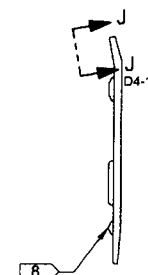
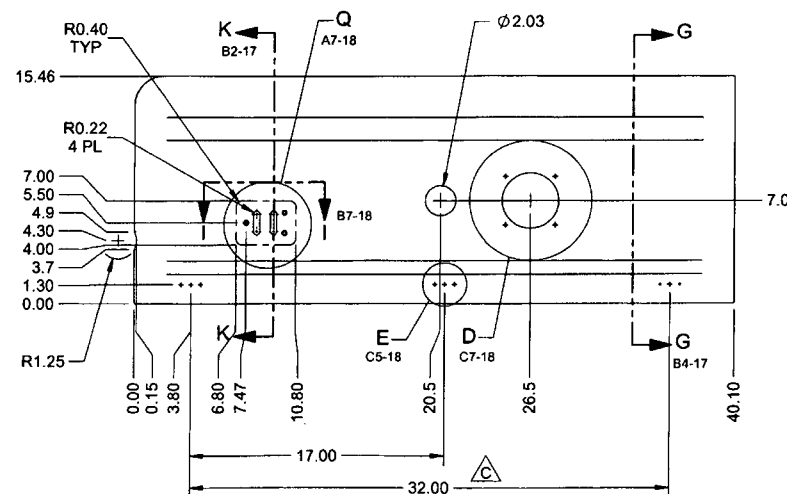
- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,  
P3-VELOUR MATTE, STEEL GRAY #52068  
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.60 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-3 PER TOOL DT9841
- 10) THERMOFORM D4635-3 PER QSI 022 USING DT9849 TOOL  
MIN. THICKNESS AFTER FORMING:  
RIDGES/EDGES = 0.060  
ELSEWHERE = 0.070

**RELEASED**  
2013-07-15

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	AG	<b>D4635</b>	SHEET 15 OF 18
APPROVED	AS	TITLE	SCALE
DE APPR.	JA	<b>OUTBOARD CEILING PANELS</b>	NTS
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**SECTION J-J** C2-16



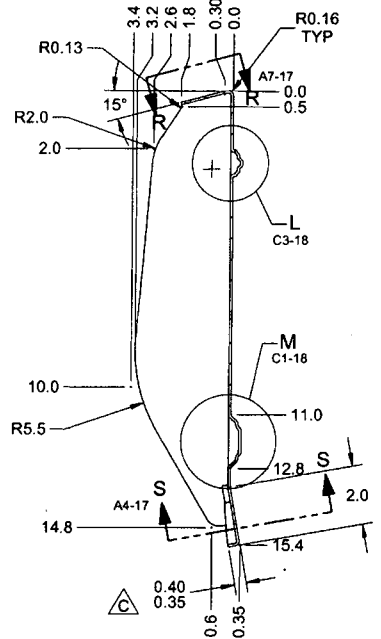
**D4635-4 RH, AFT CEILING PANEL**

**NOTES:**

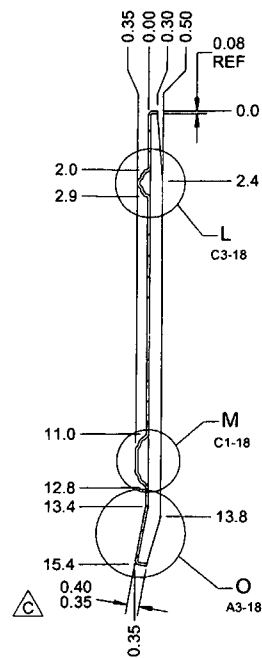
- 1) MATERIAL: KYDEX 6185 SHEET, 0.080 THICK,  
P3-VELOUR MATTE, STEEL GRAY #52068  
PER DART SPEC MKYD6185S.080-P3-52068
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 2.60 lbs
- 8) TEXTURE ON THIS SIDE
- 9) TRIM D4635-4 PER TOOL DT9842
- 10) THERMOFORM D4635-4 PER QSI 022 USING DT9850 TOOL  
MIN. THICKNESS AFTER FORMING:  
RIDGES/EDGES = 0.060  
ELSEWHERE = 0.070

**RELEASED**  
2013-07-15

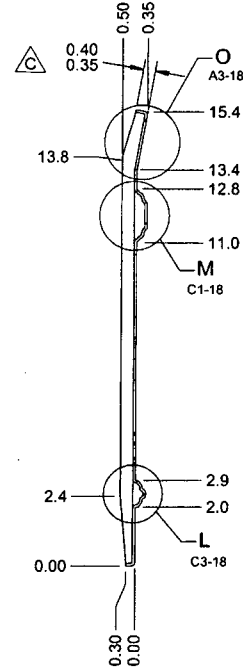
DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	DL	DRAWING NO.	REV. C
MFG. APPR.	DL	<b>D4635</b>	SHEET 16 OF 18
APPROVED	DL	TITLE	SCALE
DE APPR.	DL	<b>OUTBOARD CEILING PANELS</b>	NTS
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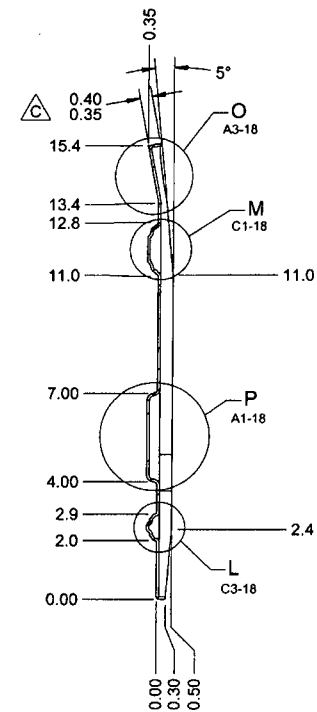
**SECTION A-A**  
**SECTION A'-A' OPPOSITE** B3-13  
**SCALE 2X** B3-14



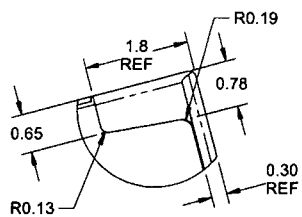
**SECTION B-B** B7-13  
**SCALE 2X** B7-14



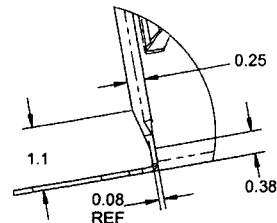
**SECTION G-G** B4-15  
**SCALE 2X** B4-16



**SECTION K-K** C6-16  
**SCALE 2X**



**AUXILIARY VIEW R-R** D7-17  
**SECTION R'-R' OPPOSITE**  
**SCALE 2X**

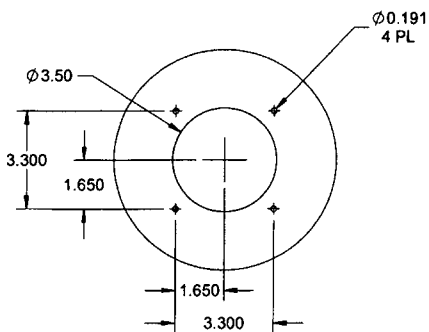


**AUXILIARY VIEW S-S** B7-17  
**SECTION S'-S' OPPOSITE**  
**SCALE 2X**

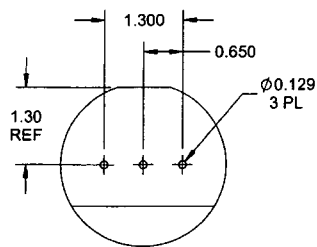
**RELEASED**  
2013-07-15  
*MD*

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	<i>DC</i>	DRAWING NO. <b>D4635</b>	REV. C
MFG. APPR.	<i>DC</i>	SHEET 17 OF 18	
APPROVED	<i>DC</i>	SCALE NTS	
DE APPR.	<i>DC</i>	<b>OUTBOARD CEILING PANELS</b>	
DATE	13.06.18	<small>COPYRIGHT © 2012 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	

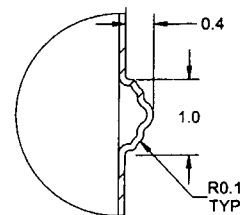
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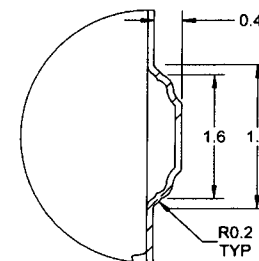
**DETAIL D**  
SCALE 2X  
B4-13  
B3-14  
B5-15  
B5-16



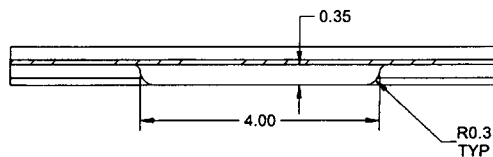
**DETAIL E**  
SCALE 4X  
C7-13  
B6-14  
C6-15  
B5-16



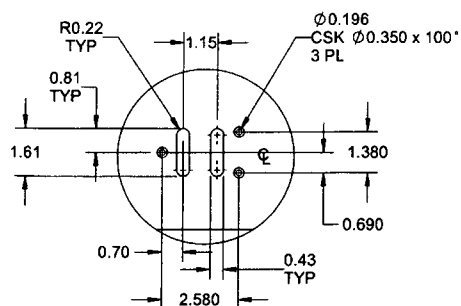
**DETAIL L**  
SCALE 1.5X  
B2-17  
B4-17  
C5-17  
C7-17



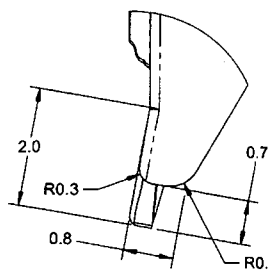
**DETAIL M**  
SCALE 1.5X  
C2-17  
C3-17  
C5-17  
C7-17



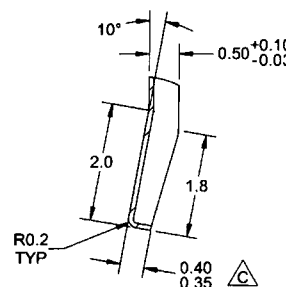
**SECTION I-I**  
SCALE 4X  
B5-16



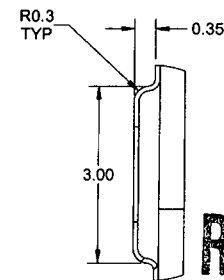
**DETAIL Q**  
SCALE 2X  
C5-16



**DETAIL N**  
SCALE 2X  
B2-13



**DETAIL O**  
SCALE 2X  
D2-17  
D3-17  
B5-17



**DETAIL P**  
SCALE 4X  
C2-17

**RELEASED**  
2013-07-15

DESIGN	RF	<b>DART AEROSPACE LTD</b> HAWKESBURY, ONTARIO, CANADA	
DRAWN	RF		
CHECKED	BC	DRAWING NO.	REV. C
MFG. APPR.	BC	D4635	SHEET 18 OF 18
APPROVED	BC	TITLE	SCALE
DE APPR.	BC	OUTBOARD CEILING PANELS	NTS
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8 7 6 5 4 3 2 1